

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Work Order ID 144653

April 21, 2016 2:39:04 PM

144653

Page 2

Item ID: D4931-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Engine Fitting (for acft models B2 & previous)
 Start Date: 5/4/2016 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 5/18/2016 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 14 9-89
120						19	0		16/05/06
QC	Memo	0.30							
Quality Control									
130	Identify as per dwg & Stock Location: <u>SA/38</u>	0.00							
130						17			DAS 6 9-89
Packaging	Memo	0.15							MAY 06 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									16/5/19
QC	Memo	1.50							
Quality Control									

MAY 09 2016

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

April 21, 2016 2:39:03 PM

Page 1

Work Order ID: 144653

144653

Parent Item: D4931-1

D4931-1

Parent Item Name: Engine Fitting (for acft models B2 & previous)

Start Date: 5/4/2016

Required Date: 5/18/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased		No			f	14.1204		3.947369			
M303R2 000									**				
303 ROUND BAR 2"													

Location

Loc Qty

Loc Code

MAT028

14.1204

m130013

0.0784

m132886

6.7

m133827

7.342

DAS

45

9-89

2016-4-28

3,691

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

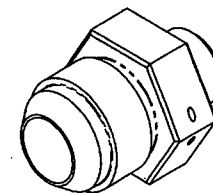
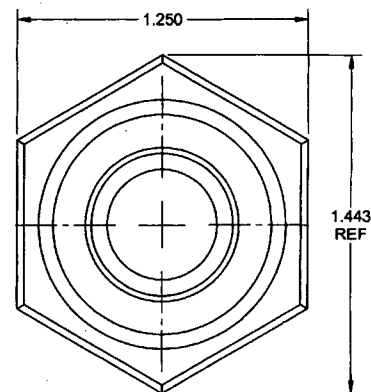
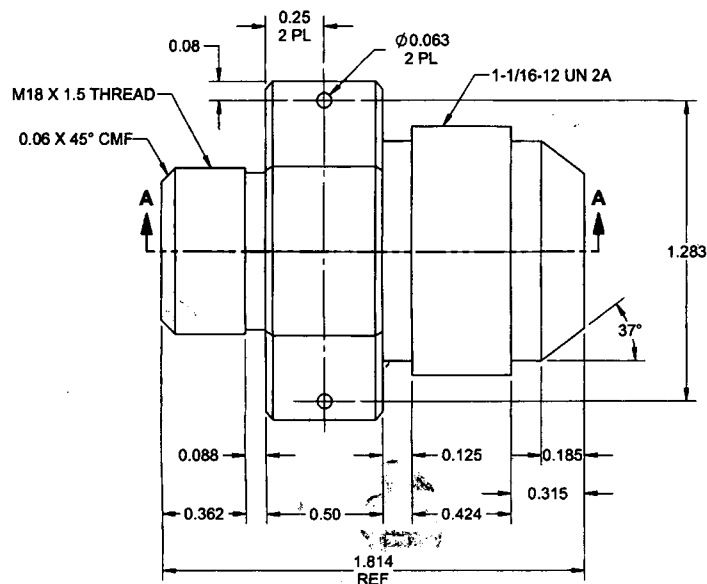
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DART AEROSPACE LTD		Work Order: 144/653
Description: EAPS P2 Engine Fitting		Part Number: D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1

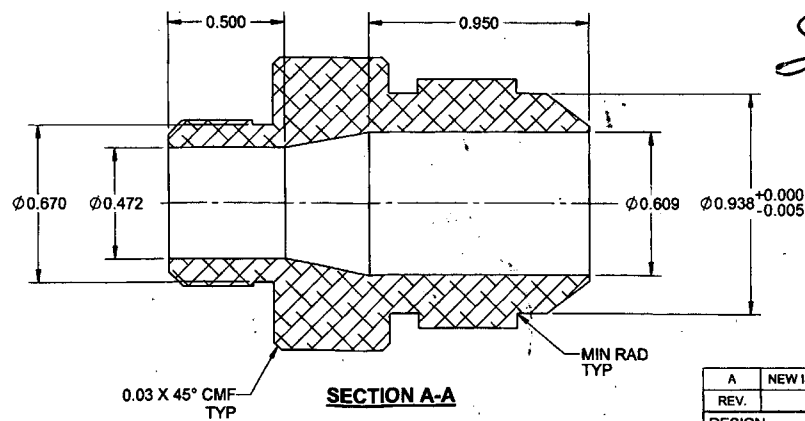
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
M18 x 1.5 Thread	GO / NO GO	OK	✓		Go-No-Go	Shop
0.06 x 45°	+/-0.030 x +/-0.5°	0.12 x 45°	✓		depth	OTC-01
0.362	+/-0.010	0.362	✓		caliper	OTC-01
0.088	+/-0.010	0.088	✓		"	"
0.08	+/-0.030	0.080	✓		HV	31006
0.25	+/-0.030	0.247	✓		caliper	OTC-01
0.50	+/-0.030	0.4985	✓			
Ø0.063	+0.004/-0.001	0.063	✓		caliper	OTC-01
0.125	+/-0.010	0.125	✓		cal + pin	OTC-01 + Shop
0.424	+/-0.010	0.424	✓		"	OTC-01
0.315	+/-0.010	0.313	✓		Caliper	OTC-01
0.185	+/-0.010	0.185	✓		"	"
37°	+/-0.5°	37°	✓		Angle	Shop
1.283	+/-0.010	1.283	✓		Angular	Shop OTC-01
1-1/16-12 UN 2A	N/A	OK	✓		nut	Shop
1.250	+/-0.010	1.245	✓		Caliper	OTC-01
Ø0.472	+0.006/-0.001	0.475	✓		"	"
0.500	+/-0.010	0.500	✓		"	"
0.950	+/-0.010	0.952	✓		"	"
Ø0.609	+0.008/-0.001	0.612	✓		"	"
0.938	+0.000/-0.005	0.9365	✓		"	"
1.814 Ref	+/-0.010	1.816	✓		"	"
M.O.W 1 1/16-12						
wire size .055	MAX: 1.0995 min: 1.093	1.098	✓		MIL T2 + PIN	OTC-03 + Shop
M.O.W M18 x 1.5						
wire size .040	MAX: 0.7378 min: 0.732	0.7365	✓		MIL T2 + PIN	Shop OTC-02
0.670	+/-0.010	0.670	✓		caliper	OTC-01

Measured by: 45 9-89	Audited by: 14 9-89	Preliminary Approval:
Date: 2016-4-28	Date: 16/05/06	Date:
Rev A	Date 14.08.27	Change New Issue
		Revised by: KJ
		Approved [Signature]



D4931-1 EAPS P2 ENGINE FITTING
(FOR MODELS B2 AND PREVIOUS)



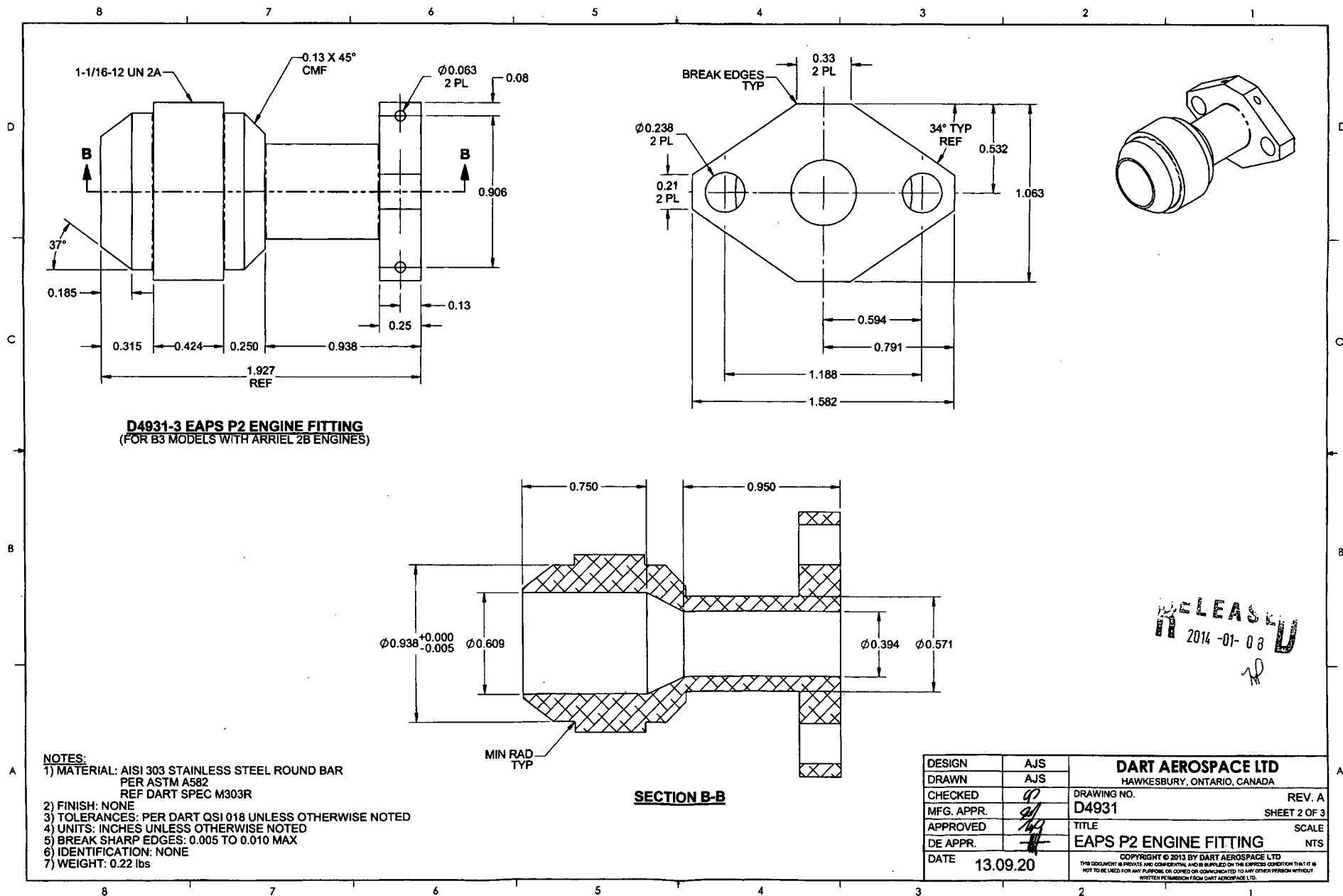
NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
OR AISI 303 STAINLESS STEEL HEX BAR
PER ASTM A582
REF DART SPEC M303H
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs

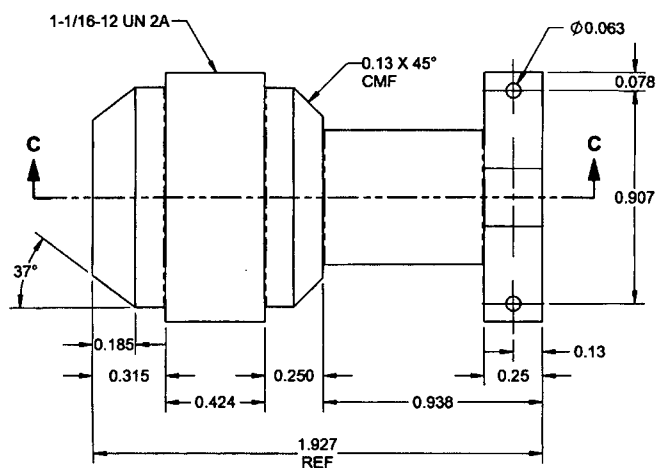
120160425
SH 144653

RELEASED
N 2014-01-03
wp

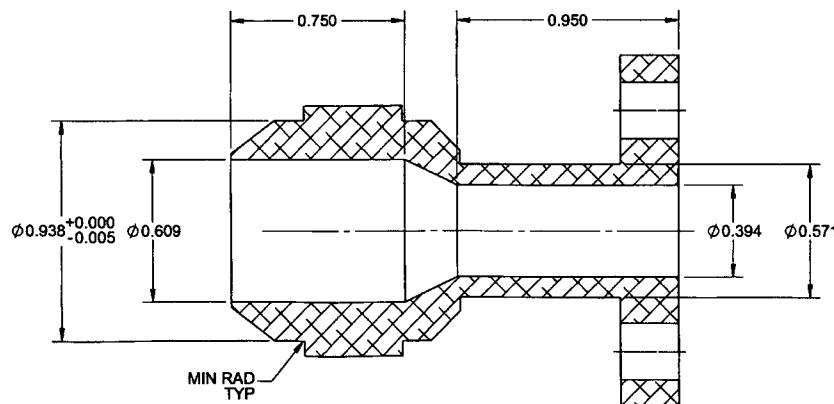
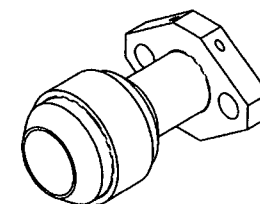
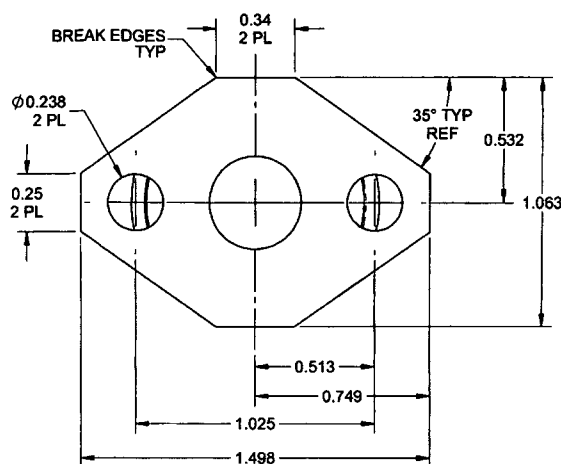
A NEW ISSUE		AJS	13.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D4931	SHEET 1 OF 3
APPROVED	97	TITLE	SCALE
DE APPR.	97	EAPS P2 ENGINE FITTING	NTS
DATE	13.09.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



D4931-5 EAPS P2 ENGINE FITTING
(FOR B3 MODELS WITH ARRIEL 2D ENGINES)



RELEASED
2014-01-08

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

SECTION C-C

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	21	D4931	SHEET 3 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	#	EAPS P2 ENGINE FITTING	NTS
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8 7 6 5 4 3 2 1